



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

654.3910

Job Sheet 207527



Part No: 654.3910

Job Qty: 6 pcs

Part Name: Handle



Part Weight: 0 lbs

Job Created: 2/27/20

Due Date: 3/6/20

Type: AOG

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG 654.3900 REV N/C IPP REV A 20.02.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run		Workcenter/Supplier		Sign-off
					Hrs	Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 5 Axis	6 pcs			0.75	2.40	HAAS - 1 - 5 - B4B		2/26-03-03
							HAAS - 2 - 5 - B4B		
110	QC 2	6 pcs			0.00	0.00	QC 2 - 1		2/26-03-03
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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CANADA
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Container No: S260502



Part: 654.3910

Job No: 207527

Serial No/Batch: S260502

Revision: N/C

Inspector:

Exp Date:

Instructions:

Date: 03/03/20

120	QC 8	6 pcs	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
150	Handfinish - 1-1 Chemical- B4B	6 pcs	0.00 0.60	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	QC 7	6 pcs	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	

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★ MAR 04 2020

RM
20-03-03

			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	BEB 20-03-04
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
170 Powdercoat - 6 Fire Red - B4B 6 pcs	0.00 0.40		Powdercoat - 1 - B4B	BEB 20-03-04
<i>See Attached Dwg For Mkng Instructions</i>			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
180 QC 3 6 pcs	0.00 0.00		QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	MAR 04 2020 DAS 40 9-89
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
210 Packaging 3-1 - Stock - B4B 6 pcs	0.00 0.00		Packaging 3 - 1 - B4B	

			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	DAS
			Packaging 3 - 20 - B4B	72
			Packaging 3 - 21 - B4B	9-89
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
220 QC 21 - SA	6 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

Part Op 100 - 1-Machine as per folio FD187 FOLIO REV: A4 DWG REV: N/C 2-Debur

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
150 - Chemical Conversion Coat per QSI005 4.1
160 - (QC7-Inspect Chemical Conversion Coat)
170 - Powder coat fire RED as per DART QSI 005 4.3.5.10 START TIME: 1:10 OVEN TEMPERATURE: 320°
FINISH TIME: 1:40
180 - (QC3- Inspect Part Finish)
210 - Identify as per dwg & Stock Location: FB Dock
220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	2.2260 ft (.371 ea)	100-HAAS 5 Axis	S240 677

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 5 Axis	M6061T6B1.000X02.000	2	15	0

Part Specifications
Specifications could not be found.

Plex 2/27/20 11:01 AM dart.lacelle.linda

DART AEROSPACE LTD	Work Order: 207 527
Description: Handle	Part Number: 654,3910
Inspection Dwg: 654,3900 Rev: N/C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.190	+0.005/-0.001	.192	✓		gauge	PIN
.23	+/- .010	.224	✓		height gauge	
.24	+/- .010	.238	✓		"	
.55	+/- .010	.554	✓		"	
R.23	+/- .010	.230	✓		Rad gauge	
Ø.202	+0.005/-0.001	.204	✓		gauge PIN	
Ø.195	+0.005/-0.001	.197	✓		"	
1.09	+/- .010	1.091	✓		Height gauge	
1.25	+/- .010	1.248	✓			
1.35	+/- .010	1.342	✓			
1.86	+/- .010	1.857	✓			
R3.00	+/- .010	3.000	✓		Rad gauge	
4.05	+/- .010	4.048	✓		Height gauge	
.230	+/- .005	.230	✓			
.658	+/- .005	.658	✓			
.755	+/- .005	.753	✓			
.846	+/- .005	.846	✓			
1.149	+/- .005	1.150	✓			
1.262	+/- .005	1.260	✓			
1.74	+/- .010	1.735	✓			
233.8°	+/- .5°	233.8°	✓		Protractor	
225°	+/- .5°	225°	✓		"	
R.19	+/- .010	.194	✓		Rad gauge	
.39	+/- .010	.388	✓		SLO2	vein
.58	+/- .010	.581	✓		"	
86°	+/- .5°	86°	✓		PROtractor	
R.13	+/- .010	.130	✓		Rad gauge	
1.57	+/- .010	1.564	✓		Height gauge	
1.05	+/- .010	1.050	✓		"	
.073	+/- .005	.070	✓		SLO2	Mic
.573	+/- .005	.575	✓		Height gauge	
.645	+/- .005	.647	✓		"	

Measured by: 20 9-80	Checked by:	QC Inspector:
Date: 20.03-03	Date: 20/03/05	Date:

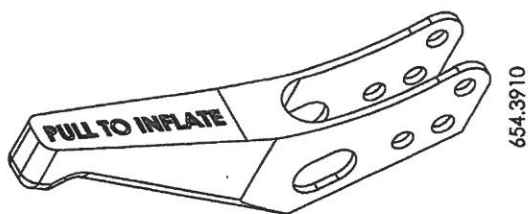
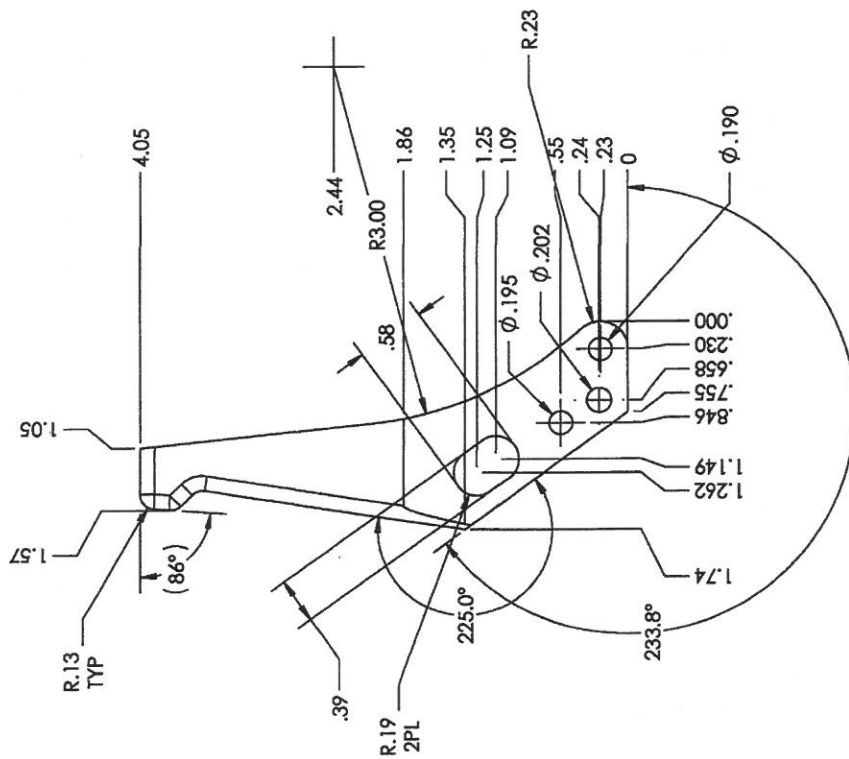
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 6061-T6
2. FINISH: RED ANODIZE IAW MPP-172 SECTION 2.2.
3. ALTERNATIVE FINISH: ALODINE PER DART QSI 005 4.1,
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3.
4. DEBURR ALL SHARP EDGES.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	02-21-2020	A. QUAN

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21-2020	A	CLIAN
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 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (601)-724-5300 AEROSPACE AERICAL INDUSTRIES, INC. 400 DART AEROSPACE		REV. N/C	
HANDLE ASSY		DWG. NO. 654.3900	
SIZE 8		CAD CODE 07M26	
SCALE NONE		SHEET 1 OF 1	